

Work Order ID 74194 RH



Page 1

Tuesday, September 27, 2011 10:09:12 AM

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 11-09-27 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Stop

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647.to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286 I doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-I doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

SW 11-10-07
SAD

BG 11/10/07

DL 11/10/13


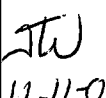


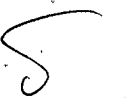
SAD 11-10-13 (1)

SAD 11-11-01 (1)
HSA

Pto →

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| | | | | | | | |

Part No: D206-642-151 PAR #: N/A Fault Category: Landing Gear Skid tubes NCR: Yes No DQA: W Date: 11/11/18
 Resolution: use as is Disposition: use as is QA: N/C Closed: CK Date: 11/11/18

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| 11/10/18 | 110-2 | while cleaning up the roller mark on the outside Bridge the operator removed too much of the Ridge about 11-10' from the Fwd CAP. |  11.10.18 OS/042 | → Ridge 0.020" high. Area not under high bearing stress Acceptable. |  11-11-02 |  11/11/18 |  11.10.18 OS/042 |  11/10/18 |
| | | R.L. LOA. operator wasn't paying attention to what he was grinding | | | | | | |
| | | | | | | | | |

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

120



QC

Quality Control

SAD 11-11-01 ①
DC 11/11/01
DP 11-11-2

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Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

OK 11/11/02

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

DP 11-11-2

Quality Control

160

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

OK 11/11/02

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

DP

11-11-2

180



Skid tubes

Skid tubes

Skid tubes

0.00

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: ☐ 11/11/02 ☐ Time: ☐ 11:40 ☐

Finish Date: ☐ 11/14/04 ☐ Time: ☐ 8:00 ☐

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☐ 119,399 ☐

Sikaflex expire date: ☐ 12/08/13 ☐

oe

11/11/02

| W/O: | | WORK ORDER CHANGES | | | | | |
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 BEC 11/24/04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☒ M117884

3-Grind welds flush as per Dwg D3804.

DP 11-11-4

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☒ N/NB

BEU/11/04

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP 11-11-4

| W/O: | | WORK ORDER CHANGES | | | | | |
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

11-11-4

215

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

Pl 11-11-08

220

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/08

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IXD M/L 11/4/08

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:40 0.00
320°F
11:10**IXD M/L 11/4/08**M 118439*

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|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 260 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 270 | HandFinishing | 0.00 | | | | | | | |
| | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. | | | | | | | | |

IRH d M. ulala

IRH d M. ulala

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

280

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

✓ A/R ☐ Sikaflex-291 ☐ 111944 ☐

Sikaflex expire date: 12/01

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4 ☐

Batch: 1118988

124 4 20 11/1/11

290

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S. W. W.

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 74194

Page 12

Tuesday, September 27, 2011 10:09:12 AM

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 300 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 310 | Packaging | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D206-642-151 | | | | | | | | |
| | Location: _____ | | | | | | | | |
| | PPP Rev: _____ | | | | | | | | |
| 320 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Sulley

PP 74375

11/11/16

11/11/17

MF 11-11-16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:07 AM

Page 1

Work Order ID: 74194

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube



Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2620

Manufactured No

110

Each

23.0000

1

1



Skidtube, 206 Skidtube



3AD 11/10/07

Location

Loc Qty

Loc Code

LG

23

71616

5

71617

6

73781

5

73786

3

73787

4



1

D2647

Manufactured No

110

Each

36.0000

1

1



Cap



OG 11/15/07

Location

Loc Qty

Loc Code

LG002

36

55352

8

71171

28

1

CR3212-4-04

Purchased No

180

Each

10,997.00

52

52



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

997

116471

78

117816

179

118686

1

118840

739

ST516

10000

119017

10000

52

DC 11/11/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:07 AM

Work Order ID: 74194



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

180 Each

12.0000 1 1



Web

Location

Loc Qty

Loc Code

LG

12

(1)

73789

10

73790

2

D3286-1 Manufactured No

180 Each

80.0000 2 2



Doubler

Location

Loc Qty

Loc Code

LG002

80

64563

6

74111

74

B740141

D2649 Manufactured No

200 Each

2,019.000 19 19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

736

68224

2

71355

2

72704

2

72841

130

73855

600

LG001

1283

65317

1

68507

11

73390

71

73857

600

73860

600

X DC 11/11/02

SAD 11-11-01

(2) 19

BE 11/11/04

19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:08 AM

Page 3

Work Order ID: 74194

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3286-3 Manufactured No

200

Each

98.0000

2

2



Spacer

Location

Loc Qty

Loc Code

LG001

83

74117

83

LG002

15

64564

15

D2680-041

Manufactured No

210

Each

40.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

LG

73854

40

73334

40

CR3212-4-03

Purchased No

210

Each

2,116.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1114

114859

1114

ST318

1000

119017

1000

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1



Washer

X

BE 11/11/04
B74439 *2

① DP 11-11-4

② DP 11-11-4

M118384 (x1) M118384

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:08 AM

Work Order ID: 74194

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

210

Each

1,401.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

399

117086

21

117849

378

ST317

1000

119017

1000

(2)

11-11-4

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

1119075

x

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

1373827

x 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:08 AM

Work Order ID: 74194



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-3

Manufactured No

270

Each

1,799.000

6

6



O-Ring



Handwritten: 11/4/11

Location

Loc Qty

Loc Code

FP-A

1799

61962

12

66956

282

73489

505

73828

1000

Handwritten: x 6

D3873-1

Manufactured No

280

Each

599.0000

14

14



Bushing



Handwritten: 11/4/11

Location

Loc Qty

Loc Code

ST084

4

68247

4

ST088

595

64760

1

70690

47

71837

87

73399

60

73829

400

Handwritten: B73830

Handwritten: x 14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:08 AM

Work Order ID: 74194

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

87.0000

1

1



Aft Cap



Handwritten: M 11/1/11

Location

Loc Qty

Loc Code

FP004

43

Handwritten: B73294

Handwritten: X1

68280

43

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear



Handwritten: B74891 (x1) M 11/1/11

MS27039-1-08

Purchased No

280

Each

1,216.000

2

2



Handwritten: M 11/1/11

Screw

Location

Loc Qty

Loc Code

ST291

1216

115108

16

117423

300

118378

400

118910

500

Handwritten: X2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:09:08 AM

Work Order ID: 74194

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No

280 Each

8,411.000 7 7



Nut



u/u/u

Location Loc Qty Loc Code

| | | |
|--------|------|--|
| ST300 | 2411 | |
| 117441 | 16 | |
| 117601 | 240 | |
| 117885 | 155 | |
| 118451 | 1000 | |
| 118927 | 1000 | |
| ST516 | 6000 | |
| 119017 | 6000 | |

x7

D3805-045 Manufactured No

280 Each

6.0000 1 1



Wearplate Assembly Aft, Low Gear



13701937 (x1) u/u/u

Location Loc Qty Loc Code

| | | |
|-------|---|--|
| FP | 6 | |
| 70878 | 6 | |

AN960JD10L NAS1149D0332J Purchased No

280 Each

0.0000 2 2



Washer



1117087 (x2) u/u/u

AN3-37A Purchased No

280 Each

261.0000 7 7



Bolt



u/u/u

Location Loc Qty Loc Code

| | | |
|--------|-----|--|
| ST353 | 211 | |
| 111668 | 111 | |
| 118628 | 100 | |
| ST354 | 50 | |
| 117619 | 50 | |

V7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 8

Tuesday, September 27, 2011 10:09:09 AM

Work Order ID: 74194



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

280

Each

4,404.000

7

7



Handwritten signature/initials

Washer

Location

Loc Qty

Loc Code

ST298

4404

117601

274

118077

1130

118612

1000

118968

2000

XI

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | Qty -041 | Qty -043 | Part Number | Description |
|------|-------------|-------------|--------------|---------------------------------|
| 1 | X | | D3804-041 | SKIDTUBE ASSEMBLY, 206 A/B LOW |
| 2 | | X | D3804-043 | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 6 | 1 | 1 | D2646 | AFT CAP |
| 7 | 1 | 1 | D2647 | CAP |
| 8 | 19 | 20 | D2649 | CROSS BOLT SPACER |
| 9 | 6 | 8 | D2651-1 | PLUG |
| 10 | 6 | 8 | D2651-3 | O-RING |
| 11 | | 1 | D2654-3 | WEB |
| 12 | 1 | | D2654-1 | WEB |
| 13 | 1 | 1 | D2680-041 | NUT PLATE |
| 14 | 2 | 2 | D3286-1 | DOUBLER |
| 15 | 2 | 2 | D3286-3 | STUD |
| 21 | 2 | 2 | AN960JD10L | WASHER |
| 22 | 1 | 1 | AN960JD416 | WASHER |
| 23 | 2 | 2 | CCR264SS3-3 | RIVET |
| 24 | 2 | 2 | CR3212-4-03 | RIVET |
| 25 | 52 | 52 | CR3212-4-04 | RIVET |
| 26 | 2 | 2 | MS27039-1-08 | SCREW |
| 27 | 1 | 1 | MS27039-4-06 | SCREW |

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

RELEASED
 09.03.03
 per ECN 09-538

| | | | |
|------------|-------------|--|--------------|
| A | NEW ISSUE | MB | 08.07.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 97 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 1 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

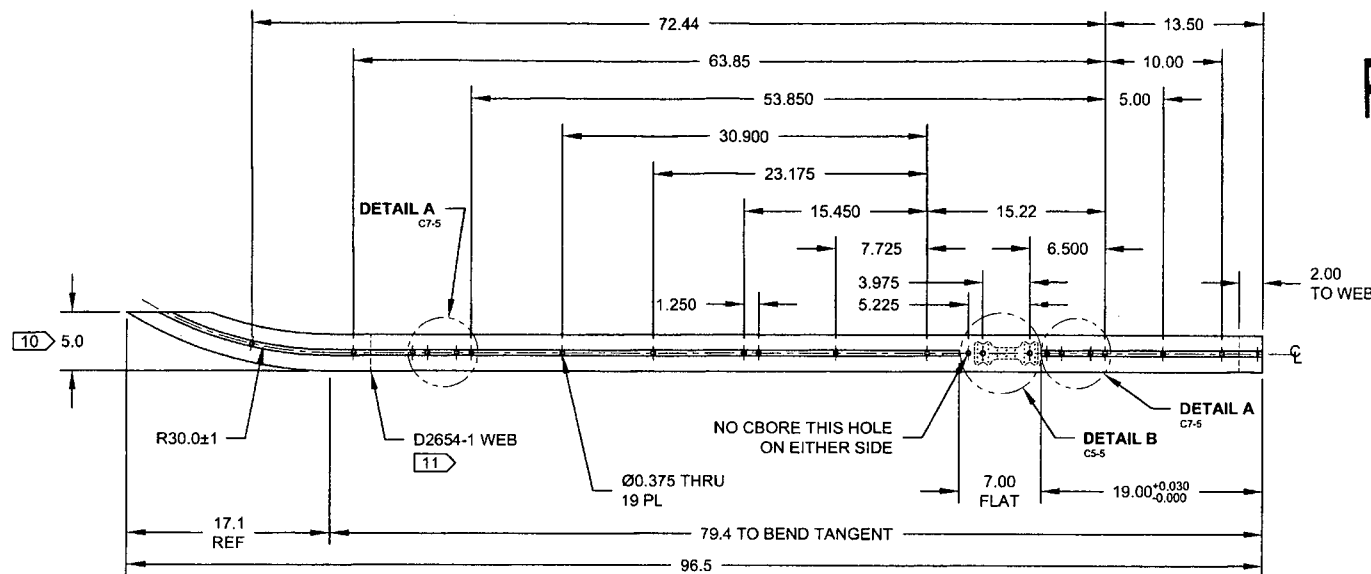
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

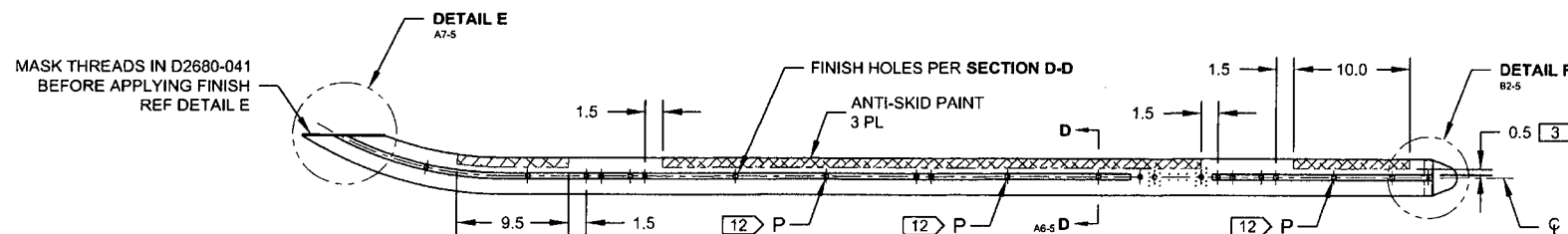
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

| | | | |
|------------|----------|--|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 1 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 2 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

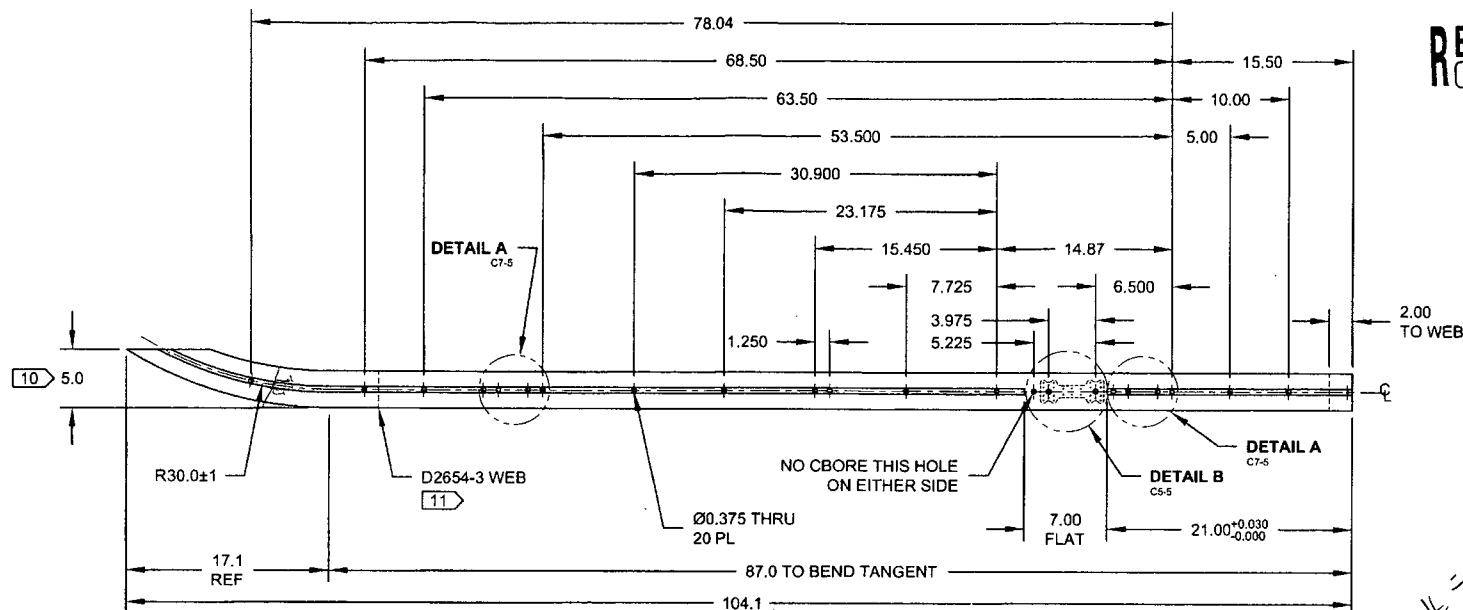
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

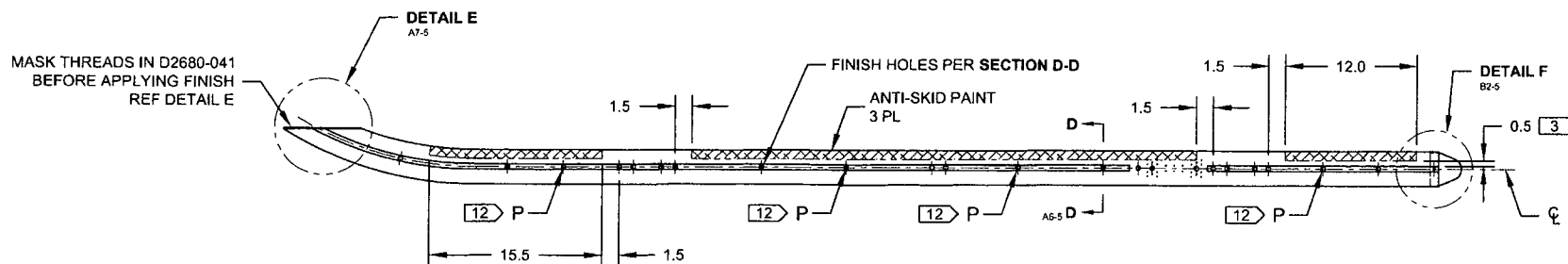
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

RELEASED
09-03-07



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

| | | | |
|------------|----------|--|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 97 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 3 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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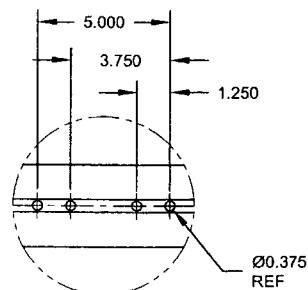
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

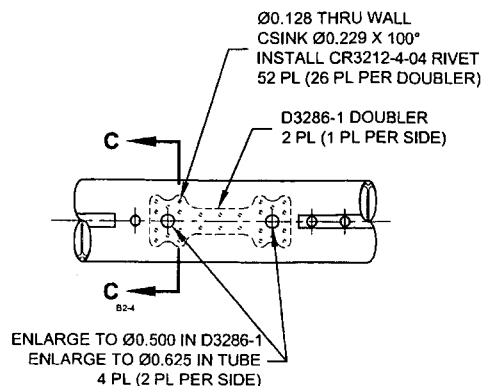
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

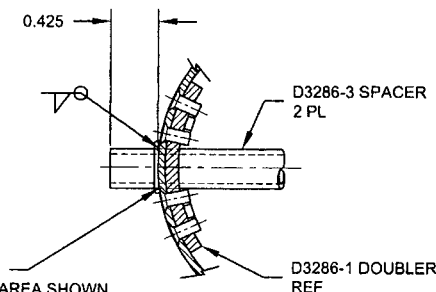
RELEASED
09.03.03



DETAIL A D6-2
C2-2
D6-3
C2-3
SCALE NONE



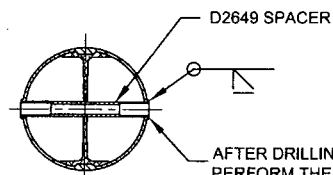
DETAIL B C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

#74194

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

| | | | |
|------------|----------|--|---------------------|
| DESIGN | 01 | DART AEROSPACE USA, INC | |
| DRAWN | 01 | PORT HADLOCK, WA | |
| CHECKED | 01 | DRAWING NO. D3804 | REV. A SHEET 4 OF 5 |
| MFG. APPR. | 01 | TITLE | SCALE |
| APPROVED | 01 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DE APPR. | 01 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

RELEASED
97 03 03

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE A7.5

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

G7.5 G

1/16

DETAIL E
SCALE NONE B7.2
B7.3

0.400

END OF WEB

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

DETAIL F
SCALE NONE B2.2
B2.3

#74194

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|------------|----------|--|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 1 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 5 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 273

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 74236
Part number: D206 642 151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal Luns Date of Test Coupon 11-10-25
Welder Barclay Elliott Date of Test Coupon 11-10-25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

